

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-013733**Date Inspected:** 05-May-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

**OUTSIDE SHOP**

SMAW welding of weld joint 3F-031 located on PCMK CA077 of Segment 10CE welder is identified as 043661. ZPMC QC is identified as Mr. Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

SMAW welding of weld joint 3F-073 located on PCMK CA078 of Segment 10CE welder is identified as 067656. ZPMC QC is identified as Mr. Li ping . The welding variables recorded by QC appeared to Comply with the WPS-B-T-4113-2.

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FCAW welding of weld joint 2G-049 located on PCMK SB012-056 of Lift 7 welder is identified as 062788. ZPMC QC is identified as Mr. Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-B-T-2232-Tc-U4b-F.

FCAW welding of weld joint 2G-049 located on PCMK SB013-060 of Lift 8 welder is identified as 062749. ZPMC QC is identified as Mr. Zhou cheng . The welding variables recorded by QC appeared to Comply with the

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## WELDING INSPECTION REPORT

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WPS-B-T-2232-Tc-U4b-F.

SMAW welding of repair weld joint 2G-007 located on PCMK SB014-050 of Lift 8 welder is identified as 062757. ZPMC QC is identified as Mr. Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-345-SMAW-2G(2F)-repair and B-WR12599.

FCAW welding of weld joint 2G-007 located on PCMK SB014-052 of Lift 8 welder is identified as 062749. ZPMC QC is identified as Mr. Zhou cheng . The welding variables recorded by QC appeared to Comply with the WPS-345-FCAW-2G(2F)-repair-1.

Fit-up of Intermediate stiffener Plate in Bike paths BK04A-008, BK04A-010, BK04A-011 started as per new fabrication procedure.

Ongoing heat straightening of FL-3 bottom plate is identified as BP3018-001 to 023 and 044 to 053 welds heating temperature and dimension measured with ZPMC QC Mr. Zhou cheng  
To comply with HSR1(B)-8016.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	McClendon,Timothy	QA Reviewer
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